

Work Order ID 73086

Thursday, August 25, 2011 1:25:40 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: ME Date: 11-08-25

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3264	Rev A2

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

29 11.8.6

6 x

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOLIO REV: AA

DWG REV: A

DEBURR AS PER DWG

B.A / ork 11/09/07
11/09/06

6 x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 11/09/07

6 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2 11. 9. 7

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6X Ø m - 11/09/08

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/12 [Signature]
MF
11-09-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, August 25, 2011 1:25:37 PM

Page 1

Work Order ID: 73086



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 8/25/2011

Required Date: 9/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.09.02 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	7.1167		3			



29 11.9.2

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

7.1167

112628 ✓

7.1167

2.875

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 73086
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.688	—		Vern ML-06	
0.063	+/-0.010	.062	—		"	
0.125	+/-0.010	.122	—		"	
0.875	+0.010/-0.020	.873	—		"	
0.062	+/-0.010	.061	—		"	
R0.03	+/-0.030	R.036	—		R-G	
R0.13	+/-0.030	R.130	—		"	
1.00	+/-0.030	1.000	—		Vern ML-06	
0.125	+/-0.010	.125	—		"	
0.600	+/-0.010	.600	—		"	
4.000	+/-0.005	4.000	—		"	
0.750	+/-0.010	.750	—		"	
Ø0.194	+0.005/-0.000	Ø.195	—		"	
5.50	+/-0.030	5.500	—		"	
0.125	+/-0.010	.125	—		"	
0.063	+/-0.010	.064	—		"	
R0.25	+/-0.030	R.250	—		R-G	
4.27	+/-0.030	4.272	—		Vern ML-06	
R0.30	+/-0.030	R.300	—		R-G	

Measured by: <i>mf</i>	Audited by: <i>RF</i>	Prototype Approval:	N/A
Date: 11/09/07	Date: 11.9.7	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>[Signature]</i>

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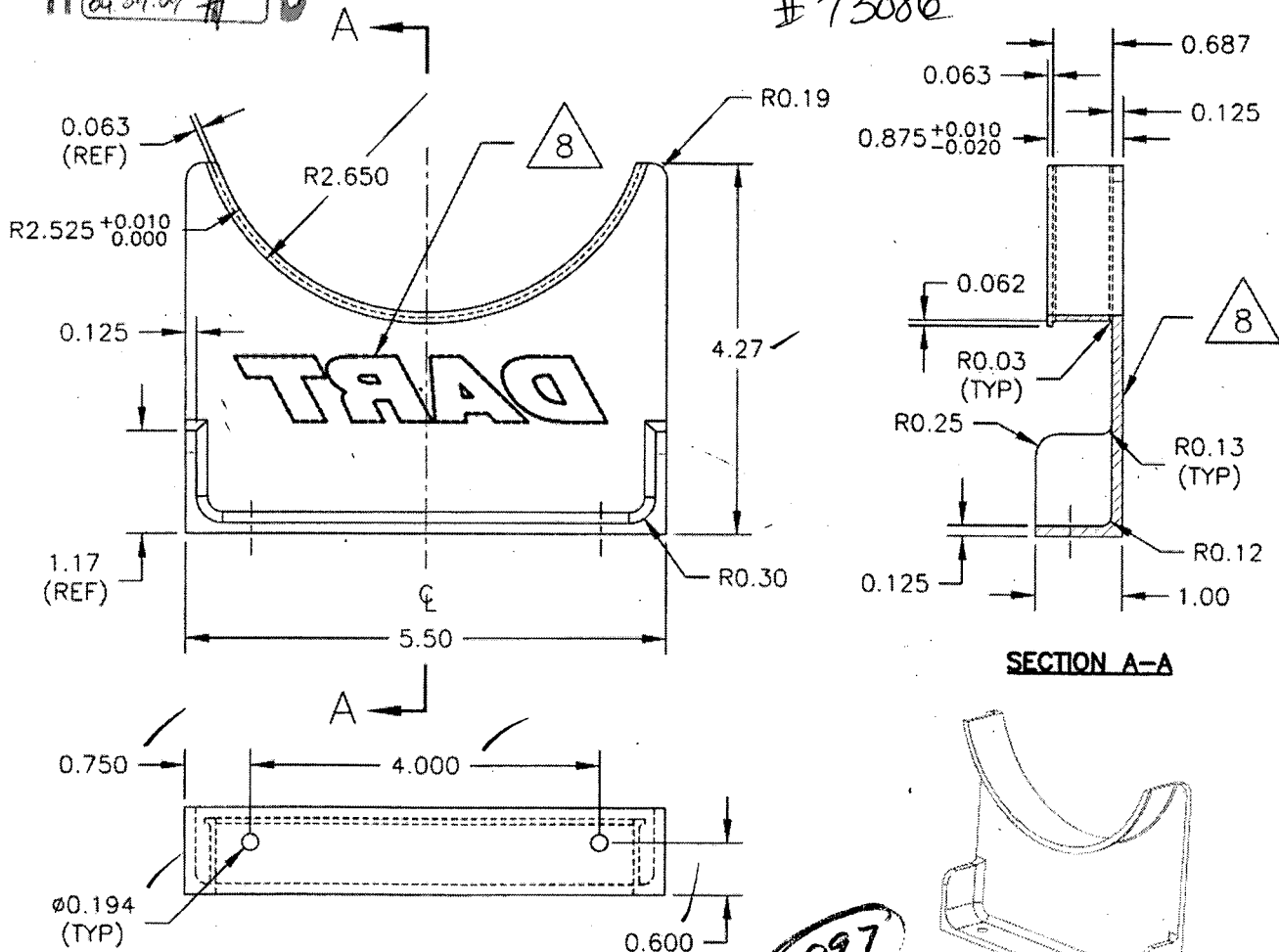
NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 #

73086



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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